



Dart Aerospace Ltd.
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D3262-041
Job Sheet 186628



+ 182197 x2

Part No: D3262-041

Job Qty: *2* ea

Part Name: Canister Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/19/18

Job Tracking No:

Due Date: 11/30/18

Created By: Marie Lajeunesse

Type: *Stock*

Description:

Note: DWG REV F SHEET 1 IPP C 05.03.10 Removed P/O for liquid penetrant inspection KJ/JLM IPP Rev:D as per ECN10-571 DD 10.05.10 verified :EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	11/30/18	11/30/18	0.00	0.00	Start Up Large Fab-1		<i>EL</i>
100	Large Fab	2 pcs	11/30/18	11/30/18	0.00	3.85	Large Fab 2	<i>DAS 24 9-89</i>	<i>EL</i>
110	QC	2 pcs	11/30/18	11/30/18	0.00	0.00	QC9		<i>CPL</i>
120	QC	2 pcs	11/30/18	11/30/18	0.00	0.00	QC5		<i>CPL</i>
130	HandFinish	2 pcs	11/30/18	11/30/18	0.00	0.51	HandFinish1		<i>DR 18/11/22</i>
140	Powdercoat	2 pcs	11/30/18	11/30/18	0.00	0.40	Powdercoat1		<i>DR 18-11-22</i>
150	QC	2 pcs	11/30/18	11/30/18	0.00	0.00	QC3		<i>NOV 28 2018 68</i>
160	Packaging	2 pcs	11/30/18	11/30/18	0.00	0.00	Packaging3-1	<i>9-89</i>	<i>NOV 28 2018 9-89</i>
170	QC21-SA	2 Ea	11/30/18	11/30/18	0.00	0.00	QC21		<i>NOV 28 2018 9-89</i>

M 138551

START: 3:40

DR T: 3:00 FINISH

4:10

DAS 24

NOV 28 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3262-1	Tube	2 Ea (1 ea)	90-Start up Operation	<i>5123156</i>
D3262-3	Cap	4 Ea (2 ea)	90-Start up Operation	<i>5110345</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3262-1	2	9	0
	D3262-3	4	13	0

Part Specifications



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Plex 11/19/18 11:08 AM Dart.lajeunesse.marie

Container No: S131310



Part: D3262 - 041

Job No: 186628

Serial No/Batch: S131310

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/26/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

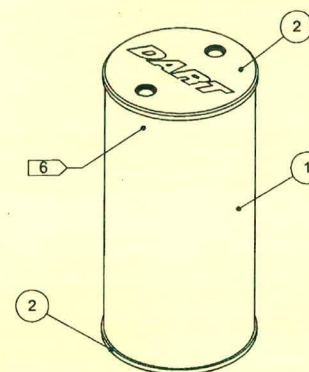
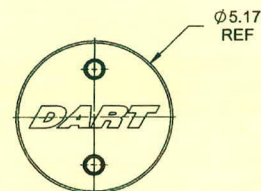
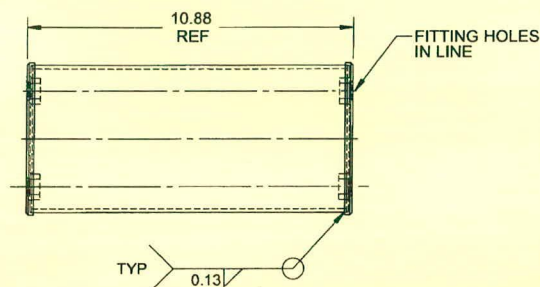
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3262-041	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-3	CAP



RELEASED
2014-07-15

D3262-041 CANISTER ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 2.51 lbs
- 8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS

F	THREAD CLASS 2B WAS 3B (ZN C3-4, B4-5, D4-5)	RF	14.06.26
E	0.25 WAS 0.45 (ZNC7-4, C7-5); 0.13 WAS 0.33 (ZN B7-4, B7-5); ADD DIMENSION (ZN B1-4, D1-5, B1-5)	RF	10.05.03
D	ADD D3262-043/-5 (ZN B5-2, B5-5); REVISE DIMENSIONS TO EQUAL TOOL DIMENSIONS (ZN B2-4; C2-4) PER CAR 09-004	RF	09.12.30
C	Ø5.165 WAS Ø5.190	RF	06.08.31
B	ADD PRESSURE TESTING OPTION	MB	05.02.14
A	NEW ISSUE	RF	04.05.06
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. F
MFG. APPR.	JLM	D3262	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	FUEL PURGE CANISTER	NTS
DATE	14.06.26	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

